

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007925**Date Inspected:** 25-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Japan Steel Works**Location:** Muroran, Japan**CWI Name:** Chung Fu Kuan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

On this date, 7/25/09, Caltrans OSM Quality Assurance Inspector (QAI) Mike Brcic was present during the times noted above for observations relative to the work being performed on cast sections in Foundry and associated built up plate sections in the Fabrication shop #4 at Japan Steel Works (JSW), Muroran, Japan.

WEST DEVIATION SADDLES

W2W3 - The welder on A shift was M.Kato 08-5018 welding joints W3Y-16U and when finished continued to weld on joint W3Y-17U-2, using SMAW and WPS SJ-3011-6 with 4mm E9018 electrode. The parameters were verified by QC CWI Mr. Chung Fu Kuan on a random basis.

TOWER SADDLES

T1-2 - Saddle section has PWHT Magnetic Particle testing being carried out by K.Kobayashi #141 of NIS team in the Fabrication shop #4. Method observed was per procedure SF-MT-01 and AWS D1.5, dry powder, continuous magnetization using a contour probe equipped with supplemental light.

T1-3 - This saddle was observed to be welded by four welders throughout the course of this QA inspector's shift. Joint 9S-2L was being welded by, Y.Watanabe 73-3873 and J.Yaegashi 07-2941; Joint 9S-3L was being welded by M.Inoue 92-5683 and T.Watanabe 08-5169. All welders were using FCAW process with WPS SJ-3012-3 and monitored randomly by Chung Fu Kuan. This observation took place in the Fabrication Shop #4.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

EAST SADDLES

E2E1 - Cast section is now had repairs completed and is undergoing a Post Repair weld Heat Treat.

E2W1 - This QA Inspector, Mr. Mike Brcic, performed a 10% QA UT verification of previously QC inspected areas of this East Saddle. Inspection parameters, technique and results can be found on Ultrasonic Inspection Report (Cast) TL-6025 dated 7/25/2009. Located in Foundry Shop.

Unless otherwise noted, all observations reported on this date appeared to be in general compliance with applicable contract documents.

Summary of Conversations:

No significant conversations to report on this day.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, 1(510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brcic,Michael	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
